

Work Order ID 58901

May 19, 2010 1:15:30 PM



Page 1

Item ID: D2362-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Pre-Flite Step

Start Date: 5/19/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2362

Rev E1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2244 extrusion 3.75" long ☐ Debur D2244-3.75 ☐ Weld D2244-3.75 to D2362-7 as per Dwg D2362 and QSI 004

10.06.07 2

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10.5 QC 6 inspect work & unclen -> 5/10/06/07 (x2)

2 PD 10.06.07

10 ->

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:45am ☐ OVEN TEMPERATURE: 320°F

=> 10/06/08 K2

Dart Aerospace Ltd

W/O: 58901		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/06/07	# 110.5	Perm. Change ADD step for QC 6 inspection	DA	10.06.14			8 10/06/07

Part No: D2362-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58901

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Page 2

Item ID: D2362-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Pre-Flite Step

Start Date: 5/19/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 10-6-8

140

HandFinishing

0.00



HandFinish

Memo

M 114432

0.00

Hand Finishing

Mask bracket and apply black anti-skid paint as per QSI 005 4.4

BR 10-6-9

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 10 06 09 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58901

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Page 3

Item ID: D2362-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Pre-Flite Step

Start Date: 5/19/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 478

0.00



Packaging

Memo

0.00

Packaging

2BB10/06/09

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14 AFMF10-6-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 19, 2010 1:15:29 PM

Page 1

Work Order ID: 58901

Parent Item: D2362-041

Parent Item Name: 350 Pre-Flite Step

Comments: IPP C000.06.26 Removed P/O for powder coat EC

Start Date: 5/19/10

Required Date: 5/28/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			100	Each	1.0421	1		10.06.07	

Location

Loc Qty

Loc Code

WA

1.0421

38023

0.0421

57850

1

2

358912

QTY = 2

10.06.07

D2362-7
Bracket

10.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	-Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



RELEASED
98.12.14 KE

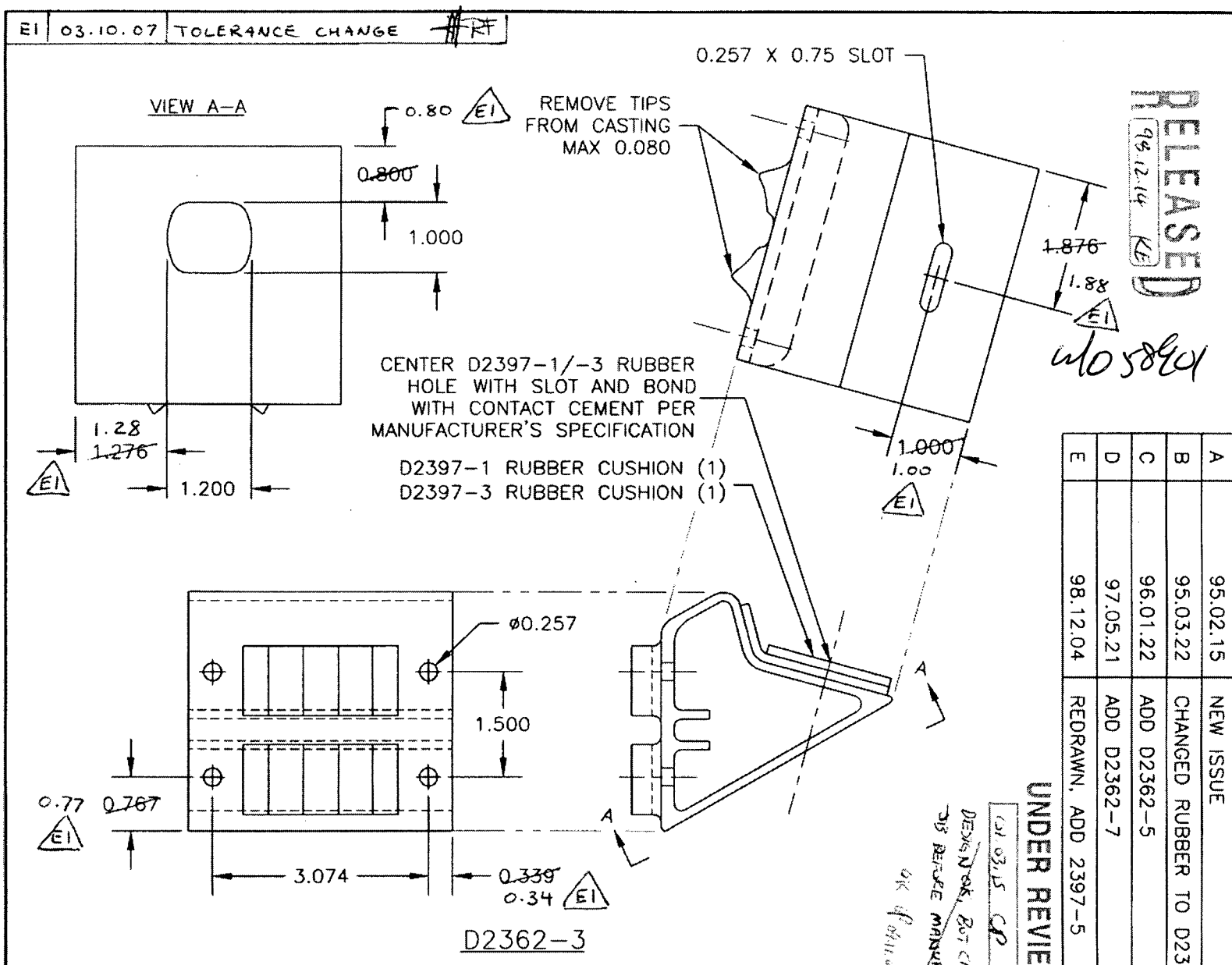
405894

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	<i>[Signature]</i>		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
<i>[Signature]</i>	<i>[Signature]</i>	D2362	
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01 03.15 CP

DESIGN OK, BUT CHECK WITH
D23 BEFORE MANUFACTURE
OK 07/11/04



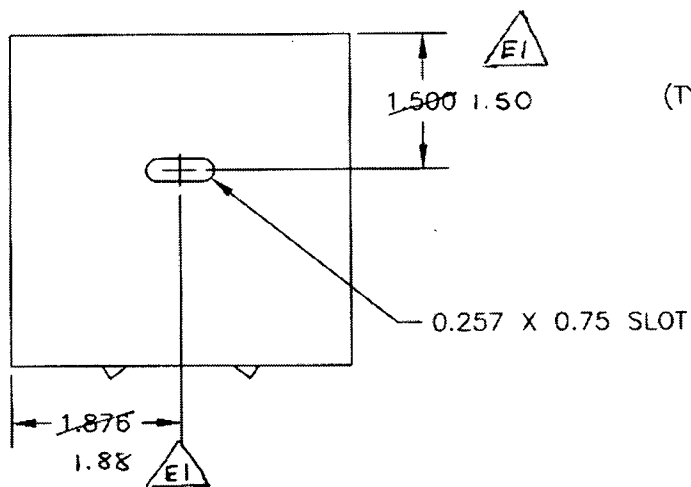
NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



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		TITLE	STEP SUPPORT BRACKET
		SCALE	1:2
		REV. E	SHEET 2 OF 3

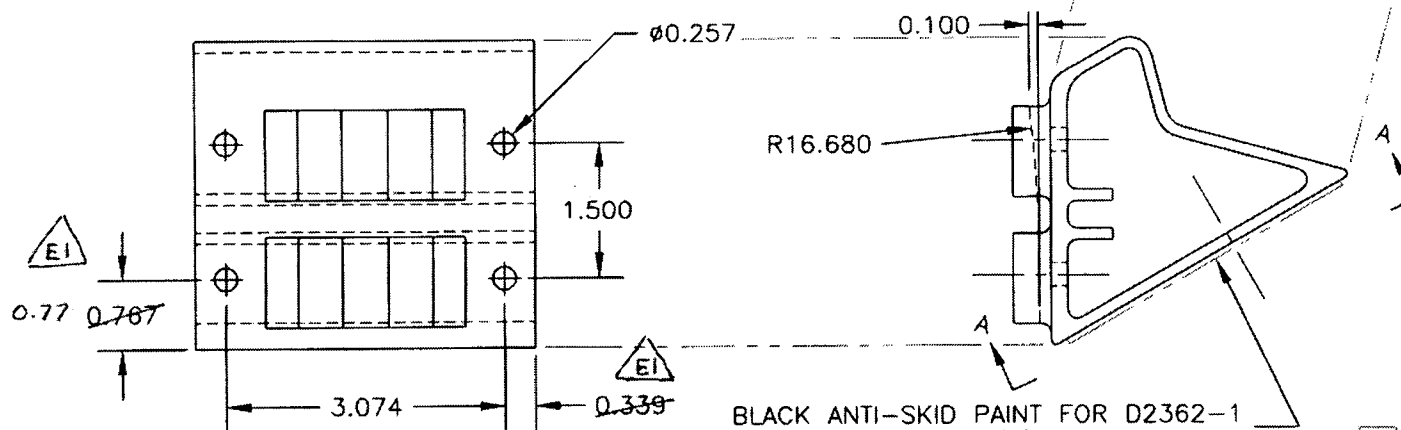
VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080

ulu
58901



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

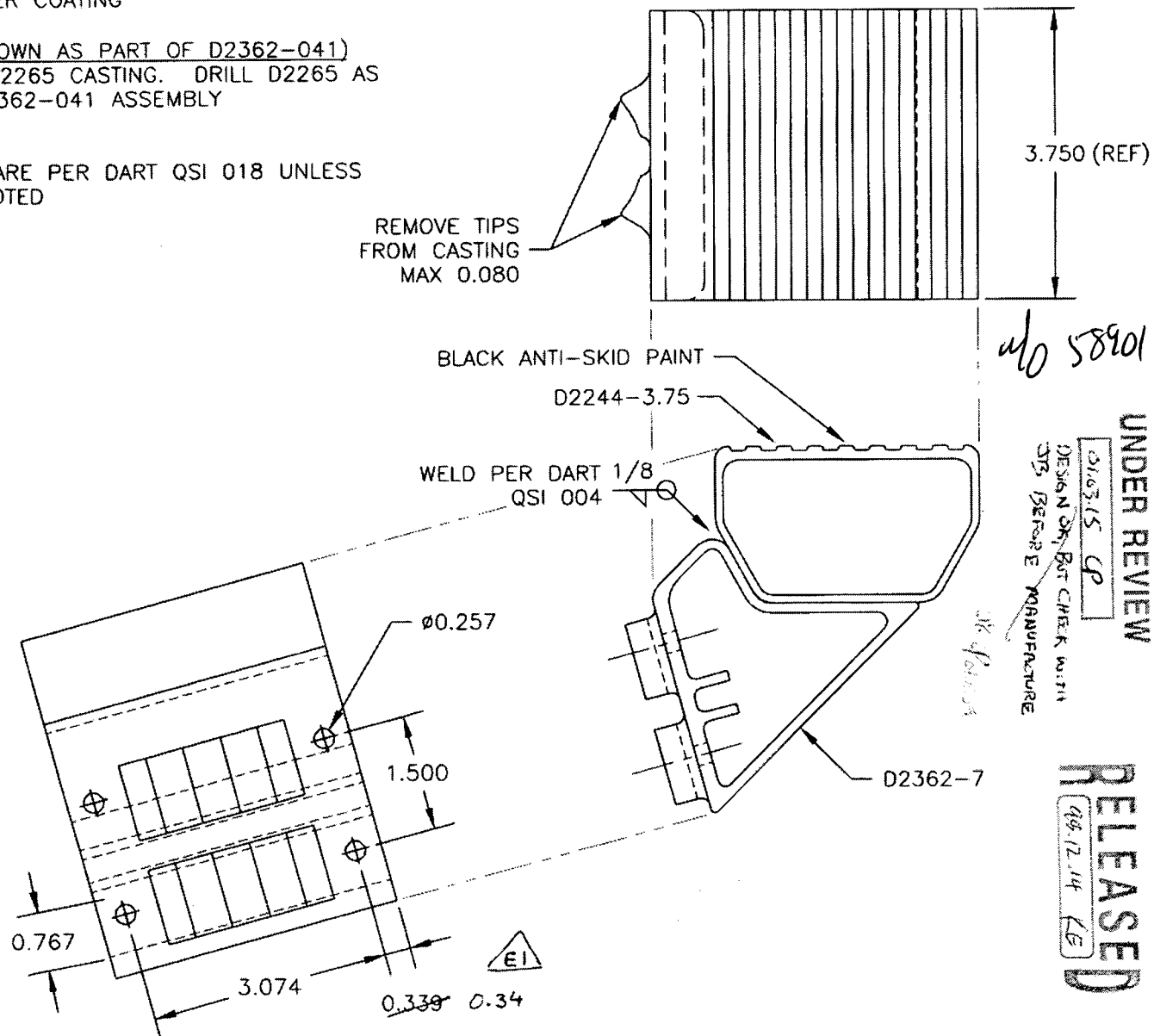
RELEASED
UNDER REVIEW
98.12.14 KE

CH 03.45 CP
DESIGNER, BUT NOT FOR MANUFACTURE
OK 4/10/99

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING




D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART



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		D2362	SHEET 3 OF 3	
DATE	TITLE		SCALE	
98.12.04	STEP SUPPORT BRACKET		1:2	

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